

Date: Monday, 3/19/2007 8:15:01 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : UTILITY BASKET LH/RH
Job Number : 31265	
Estimate Number : 10236	
P.O. Number :	Part Number : D350607047
This Issue : 3/19/2007 S.O. No. :	Drawing Number : D350-607 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : F
Previous Run : 30859	Material :
Written By :	Due Date : 4/4/2007 Qty: 1 Um: Each
Checked & Approved By : <u>3/07.03.19</u>	
Comment : Est Rev:B Re-Format 05-11-03 JLM	
Est Rev:C As per DSI9318 06-09-05 JLM	

## Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPPD350-607-047-CH0001

CH0001

S 08/08/05

2.0	31265A	350 BASKET BASE (SHORT)
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Comment: Sub-Component 350 BASKET BASE (SHORT)

D3265-041 B 31265A

E 08/08/05 @

3.0	31265B	BASKET LID ASSEMBLY
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Comment: Sub-Component BASKET LID ASSEMBLY

D3267-043 B 31265B

E 08/08/05 @

4.0	31265C	BASKET LID ASSEMBLY
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Comment: Sub-Component BASKET LID ASSEMBLY

D3267-041 B 31265C

E 08/08/05 @

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

6.0	D2022101	Spacer
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Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Spacer

Batch: 37521

S 08/08/01 (X)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 3/19/2007 8:15:01 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UTILITY BASKET LH/RH

Job Number: 31265

Part Number: D350607047

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D2258200

Weight Placard 200lb



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D2258-200

Label

39439

AS 08/08/01 (X)

8.0

D2332041

Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D2332-041

Prop Ass'y

28597

AS 08/08/01 (X)

9.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D2530

Handle Weldment

40211

AS 08/08/01 (X)

10.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2535

Spring

37071

AS 08/08/01 (X)

11.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2537

Bushing

39153

AS 08/08/01 (X)

12.0

D27283

Dart Logo label large



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2728-3

Label

22553

AS 08/08/01 (X)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

Date: Monday, 3/19/2007 8:15:01 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UTILITY BASKET LH/RH

Job Number: 31265

Part Number: D350607047

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2931

Bumper

21139

AS 08/08/01 (X)

14.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt

107737

AS 08/08/01 (X)

15.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-13A

Bolt

M679 59

AS 08/08/01 (X)

16.0

AN422A

Bolt



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

7 AN4-22A

Bolt

M107715

AS 08/08/01 (X)

17.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN5-17A

Bolt

08205

AS 08/08/01 (X)

18.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD8

Washer

M107650

AS 08/08/01 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 8:15:01 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UTILITY BASKET LH/RH

Job Number: 31265

Part Number: D350607047

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN960JD416

Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

14 AN960JD416 Washer

M108101

AS 08/08/01 (X)

20.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416L Washer

108138

AS 08/08/01 (X)

21.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer

M107959

AS 08/08/01 (X)

22.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer

M108377

AS 08/08/01 (X)

23.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS20600AD4W3 Rivet

M18071

AS 08/08/01 (X)

24.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3)

M107605

AS 08/08/01 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UTILITY BASKET LH/RH

Job Number: 31265

Part Number: D350607047

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

MS21042L4

Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

nut

Batch:

M107478

JS 08/08/01 (X)

26.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L5

Nut (or -5)

M107439

JS 08/08/01 (X)

27.0

NAS1515H4

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch:

M106919

Batch not in comp?

JS 08/08/01 (X)

28.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D350-607

JS 08/08/05 @

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/05 (X)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

31.0

D22301

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-1

Lug

39315

JS 08/08/01 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UTILITY BASKET LH/RH

Job Number: 31265

Part Number: D350607047

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-3

Clamp

39404

AS 08/08/01 (X)

33.0

D23241

Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 \*D2324-1

Strut Ass'y

39152

AS 08/08/01 (X)

34.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 0.6000 f(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2856-400-720 Abrasion Strip

37607

AS 08/08/01 (X)

35.0

AN412A

Bolt



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

5 AN4-12A

Bolt

M105143

AS 08/08/01

36.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN4-13A

Bolt

M107959

AS 08/08/01 (X)

37.0

AN960JD416

Washer



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

26 AN960JD416

Washer

M108164

AS 08/08/01 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 3/19/2007 8:15:01 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UTILITY BASKET LH/RH

Job Number: 31265

Part Number: D350607047

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total: 13.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

13 MS21042L4

Nut (or -4)

M107478

AS 08/08/01 (X)

39.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/8/5

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-607-047

Location: B

8/8/6

SY

41.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/08/07

Job Completion



MF 080807

14DS19380-011 B 40889

per ECN1068

AS 08/08/01 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9318	REV. A SHEET 1 OF 1
DATE 06.01.06		TITLE WASHER ADDITION	SCALE NTS
A	06.01.06	NEW ISSUE	

## DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607 REV. F

REF. CANADIAN STC: SH94-14 ISSUE 4

REF. FAA STC: SR00213NY

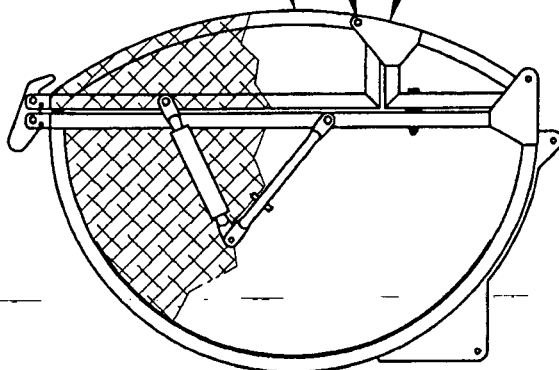
To reduce the possibility of damaging the finish, a **NAS1515H4** washer (2 places) has been added between the hinge plate and basket frame on the **D350-607-043/-047 Heli-Utility-Basket**.

The corrected bolt stackup from Figure 5 of installation instructions D350-607 Rev. F is given below:

AN4-13A BOLT (1)  
AN960JD416 WASHER (1)  
HINGE PLATE (REF)  
**NAS1515H4 WASHER (1)**  
BASKET FRAME (REF)  
AN960JD416 WASHER (1)  
MS21042L4 NUT (1)  
(2 PLACES)

BASKET FRAME (REF)

HINGE PLATE (REF)



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31265

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 06.01.06  
CERT. NO.: SH94-14  
ISSUE NO.: 4

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Date: Monday, 3/19/2007 8:15:01 AM  
 User: Kim Johnston

## Process Sheet

14

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : UTILITY BASKET LH/RH  
 Job Number : 31265  
 Estimate Number : 10236  
 P.O. Number :  
 This Issue : 3/19/2007 S.O. No. :  
 Prsht Rev. : NC Part Number : D350607047  
 First Issue : 7/1 Type : LARGE FAB ASSY Drawing Number : D350-607 REV F  
 Previous Run : 30859 Drawing Revision : F  
 Material :  
 Due Date : 4/4/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : 07.03.19  
 Comment : Est Rev:B Re-Format 05-11-03 JLM  
 Est Rev:C As per DSI9318 06-09-05 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



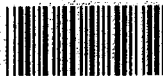
Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPPD350-607-047 CHG001002 + DSI9380 Rev.B kit 07.03.22

Has DSI 9273 Rev.B 07.06.06

07.11.20

2.0 31265A 350 BASKET BASE (SHORT)



Comment: Sub-Component 350 BASKET BASE (SHORT)

D3265-041 B

3.0 31265B BASKET LID ASSEMBLY



Comment: Sub-Component BASKET LID ASSEMBLY

D3267-043 B

4.0 31265C BASKET LID ASSEMBLY



Comment: Sub-Component BASKET LID ASSEMBLY

D3267-041 B

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

6.0 D2022101 Spacer



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Spacer

Batch:

REFERENCE ONLY



Date: Monday, 3/19/2007 8:15:37 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 31265B		
Estimate Number	: 10226		
P.O. Number	:	Part Number	: D3267043
This Issue	: 3/19/2007 S.O. No. :	Drawing Number	: D3267 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 30859B	Material	:
Written By	:	Due Date	: 4/4/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>4/07.03.19</u>		
Comment	: Est Rev:C Removed -041 05-11-04 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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Comment: Qty.: 7.3500 f(s)/Unit Total : 7.3500 f(s)  
 3/4" x 3/4" x 0.063" wall 304/316 SS tubing  
 Batch: M1085550

SAN 08/07/21 (D)

2.0	D31663	Basket Hoop
-----	--------	-------------



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)  
 Qty 1 D3166-3 Basket Hoop  
 Batch: 38780 check Lid 041"  
 Note: D3166-3 included in D3267-041 BOM

SAN 08/07/21 (D)

3.0	D31821	Hinge
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Pick:  
 Qty Part number Description Batch  
 2 D3182-1 Hinge B39336

PD 08-07-31

4.0	D34423	Shim
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Pick:  
 Qty Part number Description Batch  
 2 D3442-3 Shim B37160

PD 08-07-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 3/19/2007 8:15:37 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 31265B

Part Number: D3267043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 4.5150 sf(s)/Unit Total : 4.5150 sf(s)

Pick:

Qty Part number

Description

Batch

4.300sf M304EX0.75-16F Expanded Metal

M108474

SAD

08/07/21

(1)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg D3267

2-Cut (4) D2236-1 From D3166-3

3-Drill holes in tubing D3267-043 as per Dwg D3267.

4-Deburr & Remove All Markings From Material

5-Weld D3267-043 Assembly using Welding Table and corner Jig as per Dwg D3267. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid.

AD 08-07-31

(1)

7.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

QC9 M108/08/01

QCS 8/8/01

8.0

POWDER COATING

POWDER COATING



M108523



(12)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M108

08/08/01

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

08/08/05

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AD 08/08/07

Job Completion



MF 08-08-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN DS	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3267	REV. B SHEET 1 OF 2
DATE 05.06.08		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	04.02.02	NEW ISSUE	
B	05.06.08	ADD SHIM UNDER HINGES	

RELEASED

05-08-19 *[Signature]*

**PARTS LIST:**

Qty -041	Qty -043	Part Number	Description
X		D3267-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D3267-043	BASKET LID ASSEMBLY (INSIDE)
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
2	2	D3265-3	STRUT
1		D3266-7	STRUT
2		D3267-1	STRUT
	2	D3442-3	SHIM

**NOTES:**

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING  
(REF. DART SPEC M304TS0.750W.060)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT  
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER  
NO. 31265B

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SKIN BASKET LID WITH 3/4-16F EXPANDED SS, TACK WELD EACH END STRAND TO EXTERNAL FRAME

D2506 LABEL PLATE CENTER ON THE BASKET

REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE

SEE DETAIL C (TYPICAL 2 PLACES)

TACK WELD EVERY 2ND STRAND TO INTERNAL FRAME MEMBERS

D2989-11 (REF)

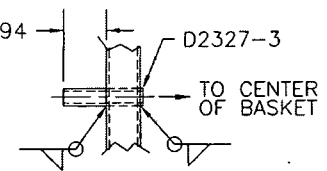
BLACK ANTI-SKID PAINT THIS SECTION

D3265-3

SEE DETAIL B

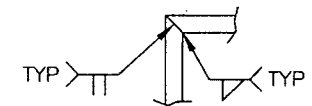
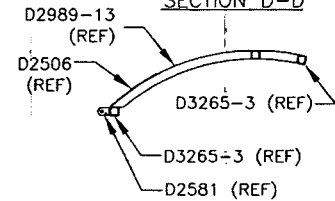
D2989-12

TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION IN AREA TO BE ANTI-SKID'D

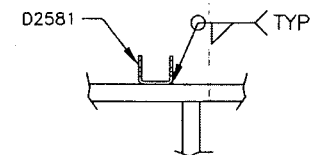


DETAIL C  
SPACER INSTALLATION

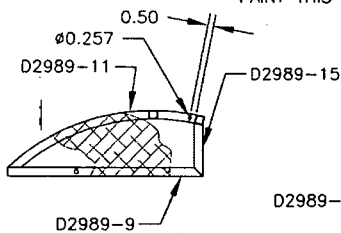
SECTION D-D



DETAIL A  
WELD ALL JOINTS AS SHOWN



DETAIL B



RELEASED

05-08-19

D2989-15 (REF)

D

D3267-041 LID ASSEMBLY

SEE DETAIL A

D3265-3

TACK WELD EVERY 2ND STRAND TO INTERNAL FRAME MEMBERS

D2989-3 (REF)

D2989-4

D3182-1 HINGE

Ø0.257 (TYP 5 PLACES)

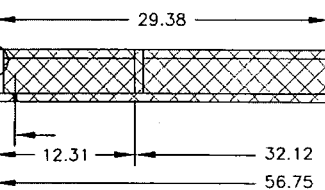
D3265-3

D2989-5

D2989-5

SKIN BASKET LID WITH 3/4-16F EXPANDED SS, TACK WELD EACH END STRAND TO EXTERNAL FRAME

DETAIL E



D2989-4

1.750 (TYP 2 PLACES)

D3182-1 HINGE

DETAIL E (SCALE 1:2) (TYP BOTH ENDS)

D3442-3 SHIM

D3267-043 LID ASSEMBLY

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DESIGN	DS	DRAWN BY	PH	<b>DART</b>	DART AEROSPACE LTD. WARRICKSBURY, OXFORD, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	D3267
DATE	05.06.08	TITLE	BASKET LID ASSEMBLY	REV. B	SHEET 2 OF 2
				SCALE	1:10

Date: Monday, 3/19/2007 8:15:23 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 BASKET BASE (SHORT)
Job Number	: 31265A		
Estimate Number	: 10209		
P.O. Number	:	Part Number	: D3265041
This Issue	: 3/19/2007 S.O. No. :	Drawing Number	: D3265 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 31088A	Material	:
Written By	:	Due Date	: 4/4/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>02.03.19</u>		
Comment	: Est Rev:C Re-Format 05-11-03 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D31661	Basket Hoop
-----	--------	-------------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)  
 Qty 3 D3166-1 Basket Hoop Batch: 40090

S/D 08/07/21 (C)

2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



Comment: Qty.: 19.2150 f(s)/Unit Total : 19.2150 f(s)  
 3/4" x 3/4" x 0.063" wall 304/316 SS tubing.  
 (M304TS0.750W.065)  
 Batch: 108550

S/D 08/07/21 (D)

3.0	D22323	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Pick:  
 Qty Part Number Description Batch  
 2 D2232-3 Hinge bracket B39334

S/S 08/07/25

4.0	D2325	Support Gusset (350 Bask
-----	-------	--------------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Pick:  
 Qty Part Number Description Batch  
 4 D2325 Support Gusset B39913

S/S 08/07/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Monday, 3/19/2007 8:15:23 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 BASKET BASE (SHORT)

Job Number: 31265A

Part Number: D3265041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23273

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2327-3

Bushing

B37541

*SL 08/07/25*

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B40086

*SL 08/07/25*

7.0

D34425

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3442-5

Shim

B24246

*SL 08/07/25*

8.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 26.0000 sf(s)/Unit Total : 26.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

26sf

M304EX0.75-16F Expanded Metal

M108152 (8)

~~M108152 (8)~~

M108474 (8)

*SAD 08/07/21*

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-CUT (3) D2235-1 FROM D3166-1

2-Drill hole in D3265-3 as per Dwg D3265

3-Remove all markings from material

4-Weld as per Dwg D3265 using Welding Table and corner JigDeburr as required

*SAD 08/07/21*

*SL 08/07/31*

*PD 08-01-31*

①

①

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 3/19/2007 8:15:23 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 BASKET BASE (SHORT)

Job Number: 31265A

Part Number: D3265041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/08/01

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

08/08/01 @

12.0

POWDER COATING

POWDER COATING



M108523



(1X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1 08/08/05

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M10852



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with White Sikaflex-291

Batch: M107893

Expiry date: 10/2008

08/08/05 @

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



08/08/05 @



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/08/05 @

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 6-A

08/08/05 @

16.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

08/08/07

Job Completion



MF 08-08-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

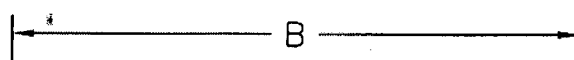
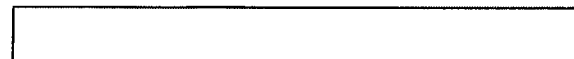
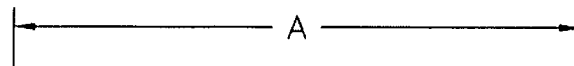
DESIGN DS	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3265	REV. B SHEET 1 OF 3
DATE 05.06.08		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS
A	04.02.02	NEW ISSUE	
B	05.06.08	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS	

**RELEASED**

05.08.19 #

PARTS LIST FOR D3265-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3265-1	2	—	56.75	RIB
D3265-3	2	—	25.50	RIB
D3265-5	2	27.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-5	2	N/A	N/A	SHIM



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WORK ORDER  
NO. 31265A

D3265-1/-3/-5

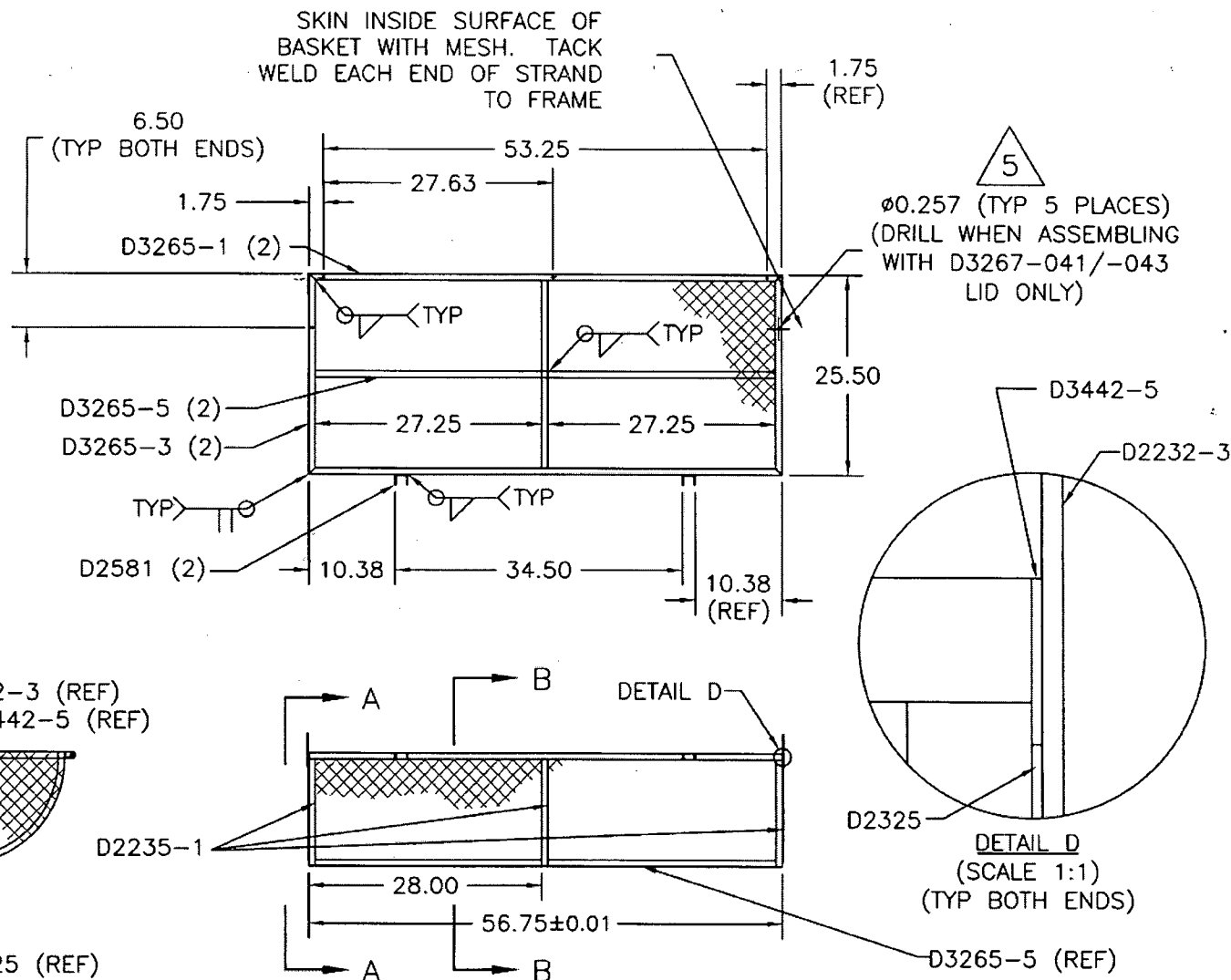
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING  
(REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL  $\phi 0.257$  HOLES ONLY WHEN ASSEMBLING  
D3265-041 BASE WITH D3267-041/-043 LID

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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.08	TITLE	D3265	REV. B
			BASKET BASE ASSEMBLY (350)	SHEET 2 OF 3
				SCALE 1:20



**D3265-041 BASKET BASE ASSEMBLY**

MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)

WELD PER DART QSI 004

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

RELEASED

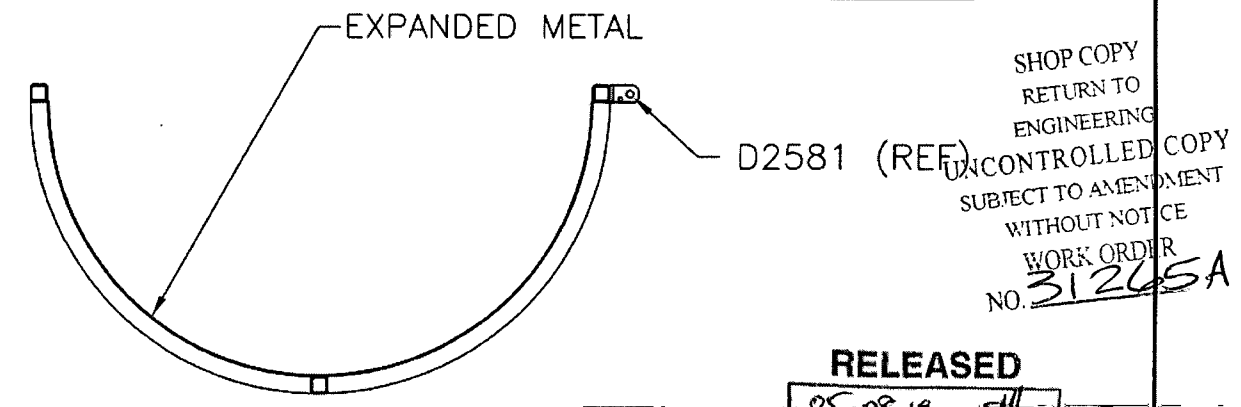
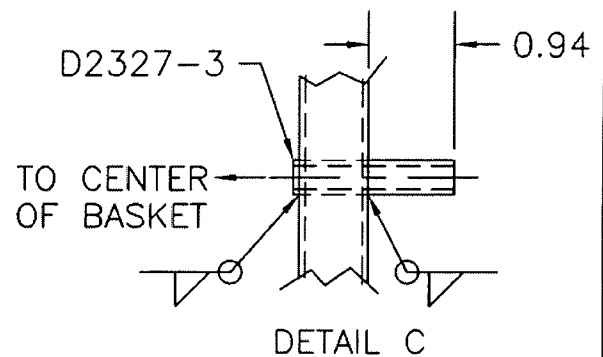
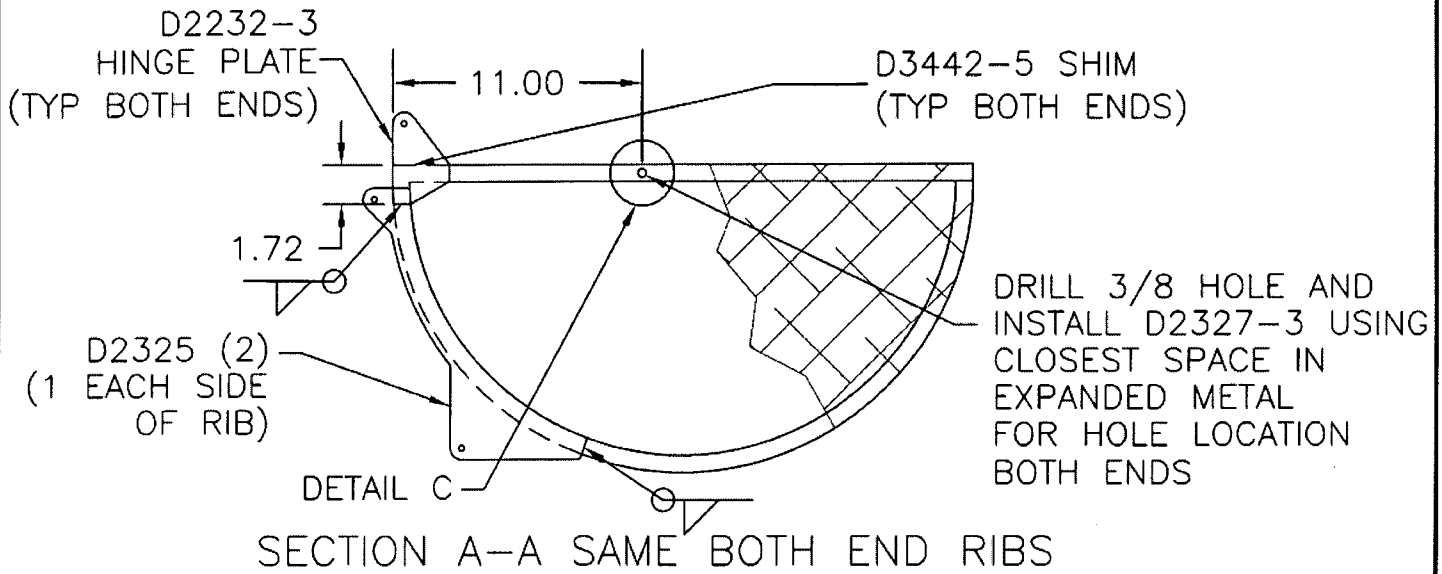
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CHECKED H	APPROVED H	DRAWING NO. D3265	REV. B SHEET 3 OF 3
DATE 05.06.08		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8

**RELEASED**

05.08.19

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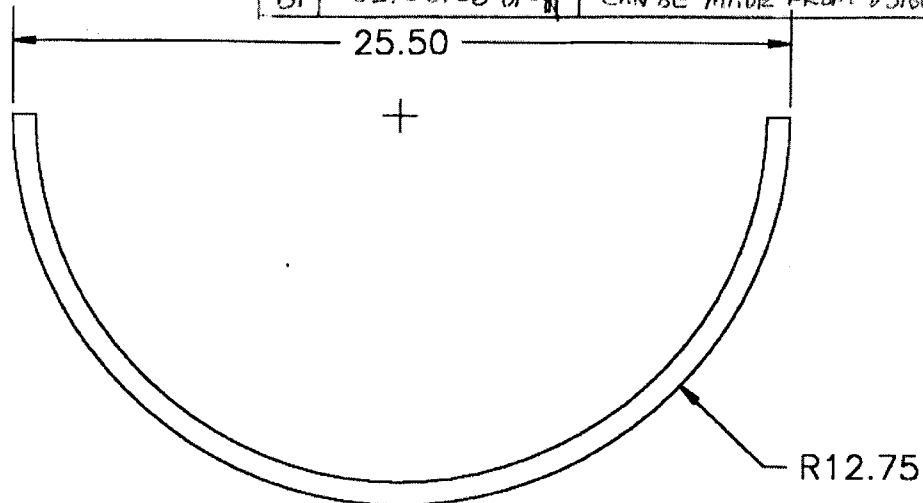
**DART**



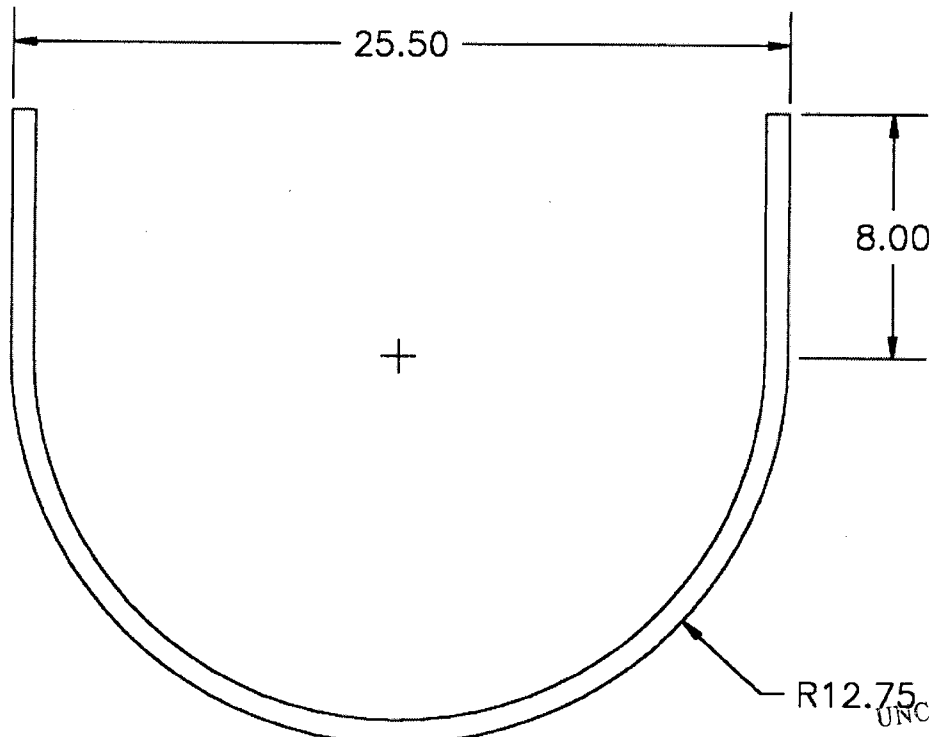
DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD. VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2235	REV. B SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS	SCALE

BI 02.08.06 *W* CAN BE MADE FROM D3166-1

RELEASED  
R 960507



D2235-1



D2235-3

CAN BE MADE FROM D3166-1 *BI*  
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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WORK ORDER  
NO. 31265A



Date: Monday, 3/19/2007 8:15:53 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 31265C		
Estimate Number	: 10212		
P.O. Number	:	Part Number	: D3267041
This Issue	: 3/19/2007 S.O. No. :	Drawing Number	: D3267 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 30859C	Material	:
Written By	:	Due Date	: 4/4/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>JA 07.03.19</u>		
Comment	: Est Rev:C Removed -043 05-11-04 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
-----	----------------	---------------------------



Comment: Qty.: 32.1300 f(s)/Unit Total : 32.1300 f(s)  
 3/4" x 3/4" x 0.063" wall 304/316 SS tubing  
 Batch: 108550

SAD

08/07/21

①

2.0	D31663	Basket Hoop
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Qty 1 D3166-3 Basket Hoop  
 Batch: 38780

SAD

08/07/21

①

3.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Pick:

Qty	Part number	Description	Batch
2	D2327-3	Bushing	<u>B39560</u>

PD 08-07-31

4.0	D2506	Placard
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Pick:

Qty	Part number	Description	Batch
1	D2506	Label Plate	<u>B39457</u>

PD 08-07-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 8:15:54 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 31265C

Part Number: D3267041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description

Batch

2 D2581

Mounting Brackets

B40086

PD 08-07-31

6.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 8.1900 sf(s)/Unit Total : 8.1900 sf(s)

Pick:

Qty Part number

Description

Batch

7.8sf

M304EX0.75-16F

Expanded Metal

M108152

M107966

SAD 08/08/21

①

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg D3267

2-Cut (4) D2236-1 From D3166-3

3-Drill holes in tubing D3267-041 as per Dwg D3267

4-Deburr & Remove All Markings From Material

SAD 08/07/21

①

5-Weld D3267-041 Assembly using Welding Table and corner Jig as per Dwg D3267. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise.Eg 2.0" along length of lid.

6-Drill Ø0.257" hole in D3267-041 as per Dwg D3267Identify as D3267-041

PD 08-02-31 ①

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/08/01

9.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

08/08/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 8:15:54 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 31265C

Part Number: D3267041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

POWDER COATING

POWDER COATING



M108523



(14)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.H. 08/08/01

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing walk as per Dwg D3267 and QSI 005 4.4

Spray Paint Black: M108593

Wing Walk: M108496

FL 08/08/04 (P)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

08/08/05 (1)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/08/07  
MF 08-08-07 (1)

Job Completion



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN DS	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3267	REV. B SHEET 1 OF 2
DATE 05.06.08		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	04.02.02	NEW ISSUE	
B	05.06.08	ADD SHIM UNDER HINGES	

**RELEASED**05.08.19 *[Signature]***PARTS LIST:**

Qty -041	Qty -043	Part Number	Description
X		D3267-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D3267-043	BASKET LID ASSEMBLY (INSIDE)
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
2	2	D3265-3	STRUT
1		D3266-7	STRUT
2		D3267-1	STRUT
	2	D3442-3	SHIM

**NOTES:**

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING  
(REF. DART SPEC M304TS0.750W.060)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT  
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SKIN BASKET LID WITH 3/4-16F EXPANDED SS, TACK WELD EACH END STRAND TO EXTERNAL FRAME

D2506 LABEL PLATE CENTER ON THE BASKET

REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE

SEE DETAIL C (TYPICAL 2 PLACES)

TACK WELD EVERY 2ND STRAND TO INTERNAL FRAME MEMBERS

D2989-11 (REF)

BLACK ANTI-SKID PAINT THIS SECTION

D3265-3

SEE DETAIL B

D2989-12

D3267-1

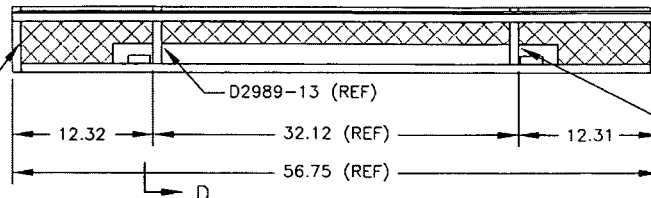
TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION IN AREA TO BE ANTI-SKID'D

D2989-13

D3265-3

D2989-15

D2989-13 (REF)



D3267-041 LID ASSEMBLY

SEE DETAIL A

D3265-3

TACK WELD EVERY 2ND STRAND TO INTERNAL FRAME MEMBERS

D2989-3 (REF)

D2989-4

D3182-1 HINGE

Ø0.257 (TYP 5 PLACES)

D3265-3

D2989-5

D2989-5

SKIN BASKET LID WITH 3/4-16F EXPANDED SS, TACK WELD EACH END STRAND TO EXTERNAL FRAME

DETAIL E

D3442-3 SHIM

D2989-3

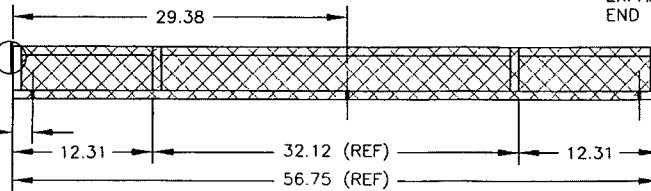
D2989-1

1.750 (TYP 2 PLACES)

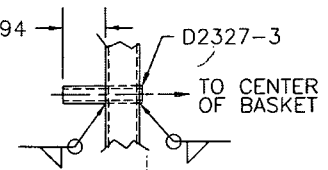
D3182-1 HINGE

DETAIL E (SCALE 1:2) (TYP BOTH ENDS)

D3442-3 SHIM

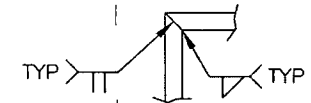
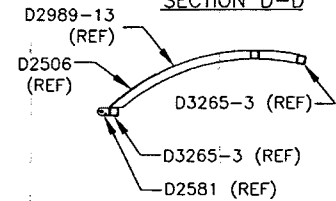


D3267-043 LID ASSEMBLY

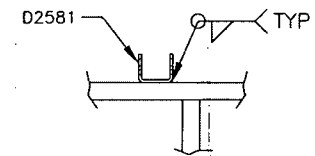


DETAIL C SPACER INSTALLATION

SECTION D-D



DETAIL A WELD ALL JOINTS AS SHOWN



DETAIL B

RELEASED

05-08-19

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DESIGN	DS	DRAWN BY	PH	<b>DART</b>	DART AEROSPACE LTD. WARRIMUR, ONTARIO, CANADA
CHECKED	PH	APPROVED	PH	DRAWING NO.	D3267
DATE	05.06.08	TITLE	BASKET LID ASSEMBLY	REV. B	SHEET 2 OF 2
				SCALE	1:10

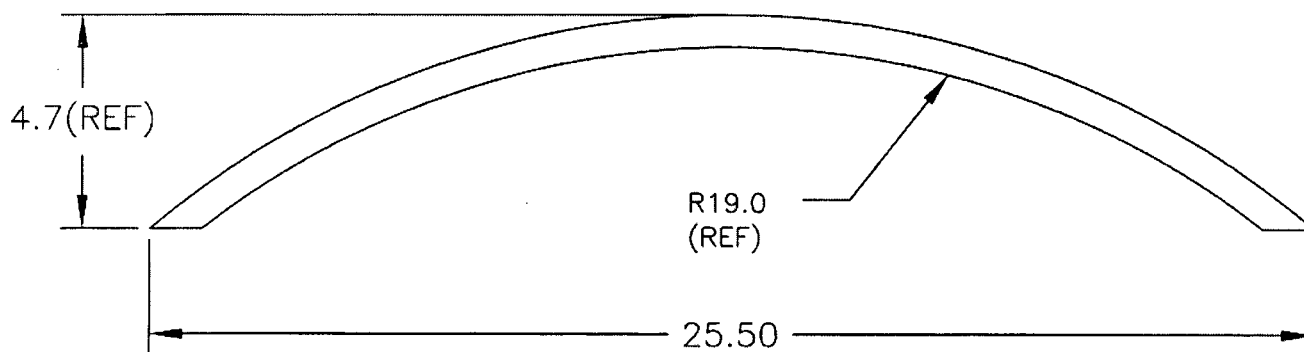




DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2236	REV. C SHEET 1 OF 1
DATE 05.06.07		TITLE LID RIB	SCALE 1:4
A	94.05.30	NEW ISSUE	
B	94.12.16	LID	
C	05.06.07	UPDATE NOTES, CHANGE RADIUS TO 19.0	

RELEASED

05-08-19 [Signature]



**D2236**

D2236 LID RIB

- 1) MAKE FROM D3166-3 BASKET HOOP
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES AER PER DART QSI 018 UNLESS OTHERWISE NOTED

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